Work Order ID 69130

Tuesday, May 03, 2011 10:16:19 AM

Item ID: D4349-17
Revision ID: PRELIM
Item Name: Bumper

Accept

Setup Start
Stop

Start Date: 5/3/2011 **Start Qty:** 2.00
Required Date: 5/3/2011 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer: ~~PRELIMINARY ISSUE~~

Run Start
Stop

Approvals: **Process Plan:** CMF **Date:** 11-05-07 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4349	~~PA6~~ A								
100	Cut blanks as per folio	0.00							
Bandsaw	**Memo**	0.00				2	ϕ		
Jeaspa Bandsaw		SA 11/5/3							
110		0.00							
Doosan	**Memo**	0.00				2	ϕ		
~~Doosan Lathe~~ Cobra	turn end radius	SA 11/6/3							
120		0.00							
Mill Conv	**Memo**	0.00				2	ϕ		
Conventional Milling Machine	mill slot as per dwg	11/05/07							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 69130

Tuesday, May 03, 2011 10:16:19 AM

Item ID: D4349-17
Revision ID: PRELIM
Item Name: Bumper

Accept

Setup **Start**
Stop

Start Date: 5/3/2011 **Start Qty:** 2.00
Required Date: 5/3/2011 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00	11/05/04			2	ø		
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00	B.A 11/05/04			2	ø		
QC	Memo	0.00							
Quality Control									
150		0.00							
Packaging	Memo	0.00							
Packaging	ID and STOCK								

Sent to Eagle

UMF 11-03-04

Work Order ID 69130

Tuesday, May 03, 2011 10:16:19 AM

Item ID: D4349-17
Revision ID: PRELIM
Item Name: Bumper

Accept

Setup Start
Stop

Start Date: 5/3/2011 **Start Qty:** 2.00
Required Date: 5/3/2011 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					11/5/10		
QC Quality Control	Memo	0.00							

POSITIVE RECALL
EFFECTIVE 11/5/4 AUTH
RELEASED DATE ~~11/05/04~~

11-05-04

Picklist Print

Tuesday, May 03, 2011 10:16:15 AM

Work Order ID: 69130

Parent Item: D4349-17

Parent Item Name: Bumper

Start Date: 5/3/2011 **Required Date:** 5/3/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: ipp revA 11.05.03 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR2.000 DELRIN ROUND BAR 2.00"		Purchased	No			100	f	20.0000	0.4	0.842105	11/5/13		

Location	Loc Qty	Loc Code
MAT050	2	
117586	2	
MAT055	18	
104930	18	

.69 ft

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69130
Description: Bumper	Part Number:	D4349-17
Inspection Dwg: 4349 Rev: PA 7		Page 1 of 1

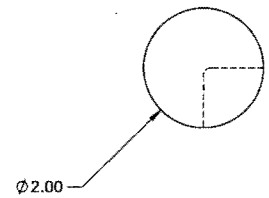
FIRST ARTICLE INSPECTION CHECKLIST

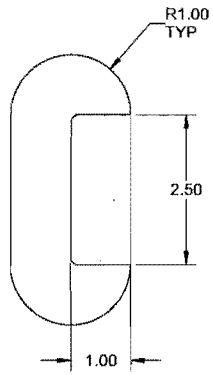
[X] First Article [X] Prototype

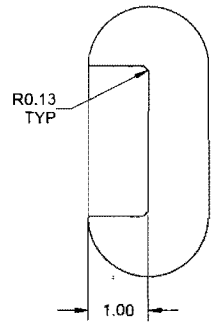
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	±.030	2.005	—		RA26	Jan
2.50	±.030	2.498	—		"	"
1.00	±.030	1.002	—		"	"
R 1.00	±.030	R1.0	—			
R 0.13	±.030	R0.125	—			

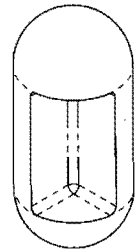
Measured by:		Audited by:		Prototype Approval:	
Date:	11/05/04	Date:	11/05/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	









#69130

D4349-17 BUMPER

NOTES:
1) MATERIAL: WHITE DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR, Ø2.000
REF DART SPEC M-DELRIN-R2.000
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.44 lbs

PRELIMINARY ISSUE
11.03.03

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4349. REV. PA7 SHEET 12 OF 12
MFG. APPR.		
APPROVED		TITLE SHELF SCALE NTS
DE APPR.		
DATE 11.03.03		

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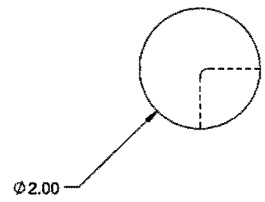

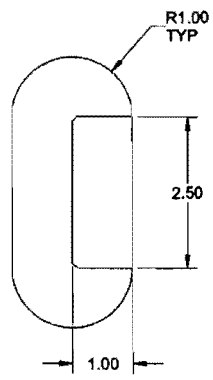

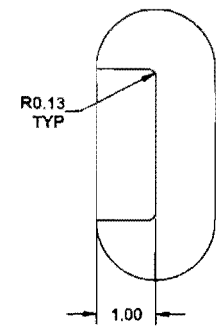

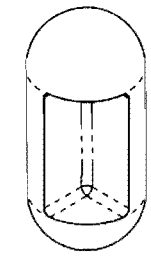

69130

D4349-17 BUMPER

RELEASED
2011 -05- 10

NOTES:
1) MATERIAL: WHITE DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR, Ø2.000
REF DART SPEC M-DELRIN-R2.000
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.44 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4349	REV. A SHEET 12 OF 12
MFG. APPR.			
APPROVED		TITLE SHELF	SCALE NTS
DE APPR.			
DATE 11.03.03			

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